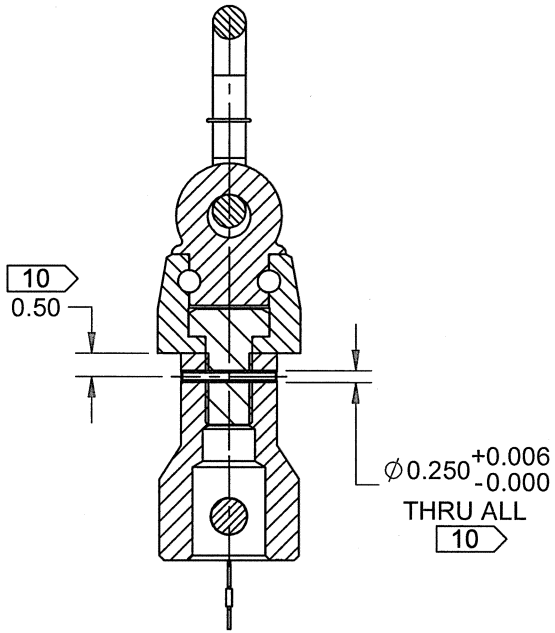
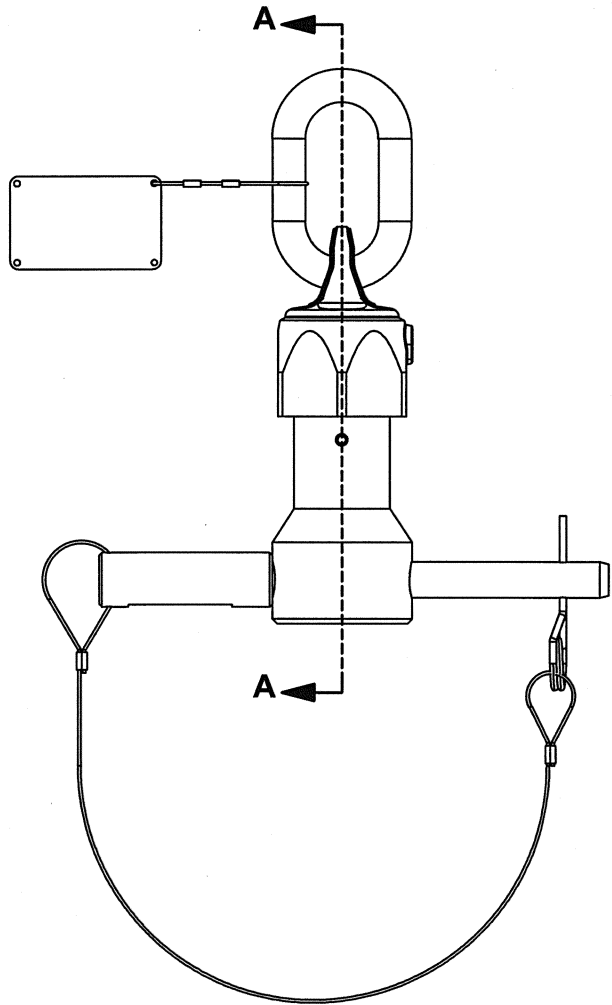
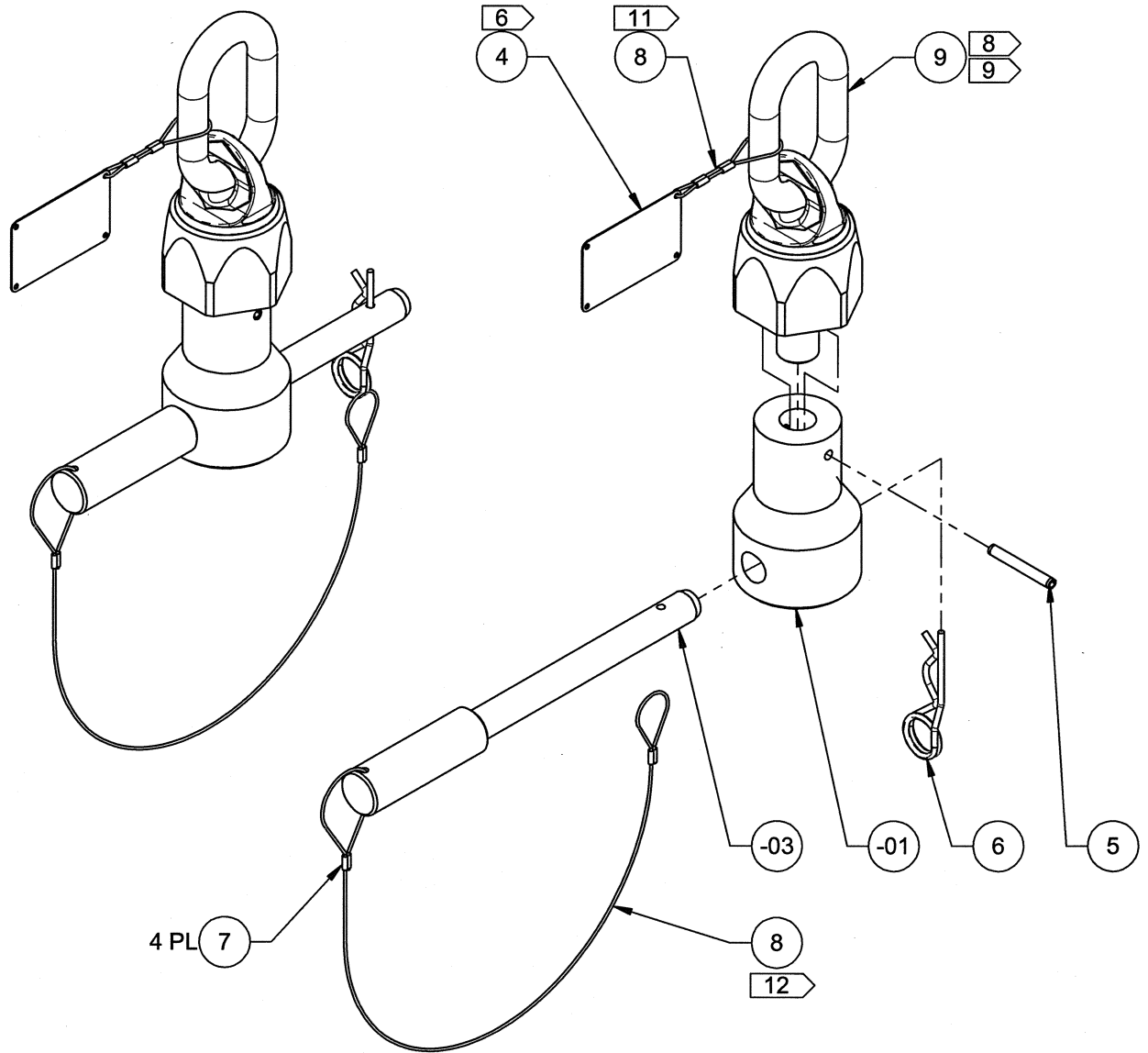


ITEM #	QTY	PART #	PART TITLE
-01	1	RBEM12669/P-1-01	BODY
-03	1	RBEM12669/P-1-03	PIN
4	1	RB41011	DART PLACARD
5	1	McMaster#97855A260 OR EQUIV	BLACK PHOSPHATE STEEL SLOTTED SPRING PIN 1/4" DIA. X 2" LG.
6	1	McMaster#98335A790 OR EQUIV	ZINC PLATE STEEL COTTER PIN FOR 5/8" TO 1" CLEVIS PIN DIA.
7	4	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
8	AR	CARR-LANE #CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.
9	1	ACTEK#44124 OR EQUIV	10,000 LBS CAPACITY 1"-8 X 1-1/2" LG. ULTRA LIFTING RING

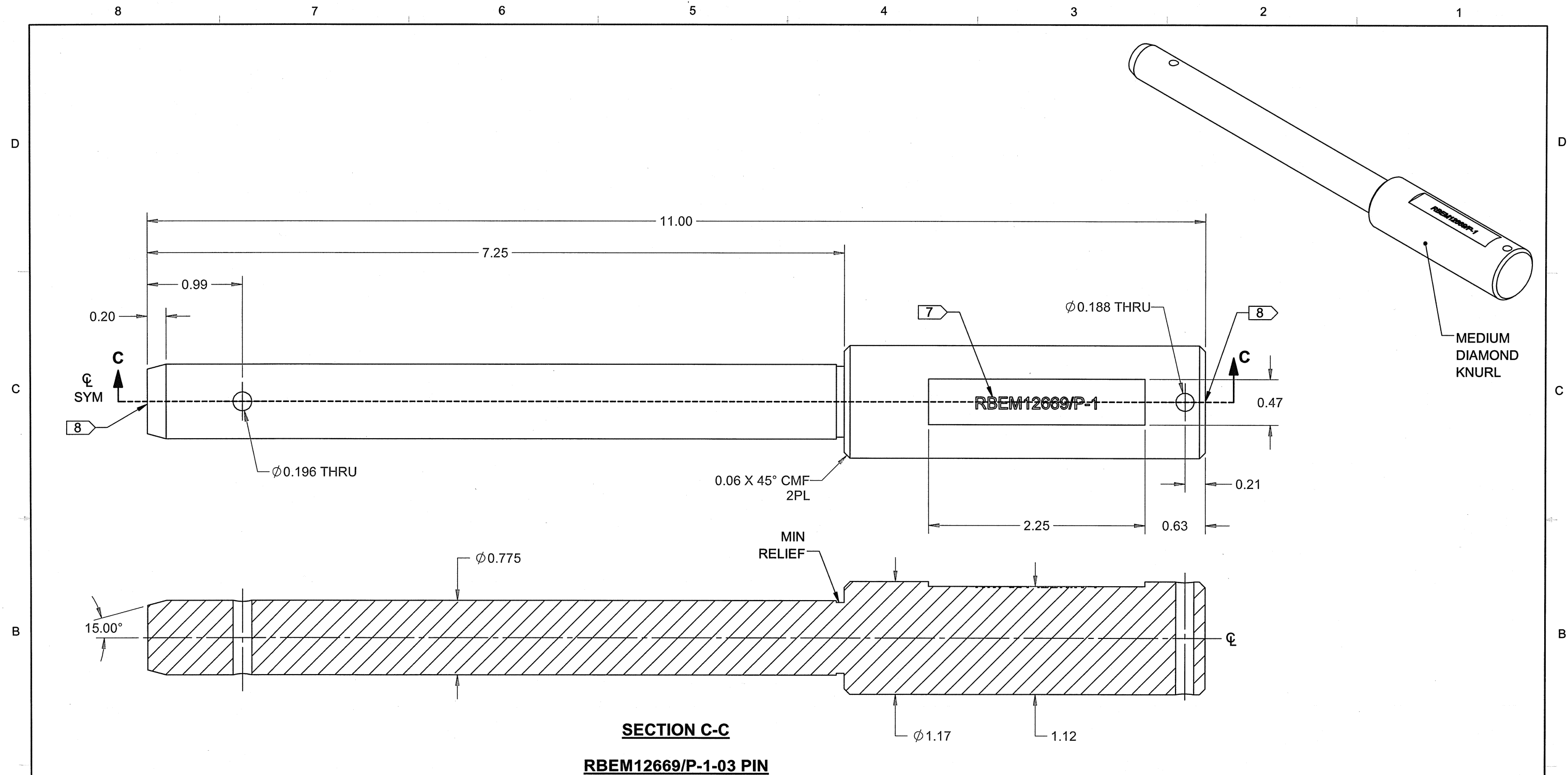


RBEM12669/P-1 HOISTING TOOL ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SWL: 3T WEIGHT TESTED AT 12,000 LBS" ON THE DART PLACARD WHERE INDICATED
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 9 THEN ASSEMBLE WITH ITEM -01, AND REMOVE EXCESS
 - 9) INSTALL ITEM 9 HAND TIGHT
 - 10) TRANSFER DRILL HOLE THROUGH ITEMS -01 AND 9 AS SHOWN, AND PRESS ITEM 5 CENTERED THROUGH ITEMS -01 AND 9
 - 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1"
 - 12) ASSEMBLED LANYARD LENGTH MUST BE 12" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM -03
 - 13) REMOVE ALL SHARP EDGES AND BURRS
 - 14) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG





SEE PREVIOUS PDFs FOR OLDER REVs TEMPLATE UPDATE PER DART HAWKESBURY STANDARDS ITEM -15 SET SCREW McMaster#92695A405 REPLACED BY ITEM 5 McMaster#97855A260 DIMENSION 5/16-18 UNC - 1B ▽ .63 CHANGED FOR Ø0.250 +0.005 / -0 THRU ALL ITEM -13 DELETED ITEM -01 DIMENSION .942 CHANGED FOR 0.94, MATERIAL 1018/1020 CR POWDER COAT RED CHANGED FOR 4140 (28-32 RC) ZINC PLATE TYPE 1 AND POWDER COAT, NOTE 8 ADDED, ENGRAVING S/N AND "MADE IN USA" REMOVED, PILOT HOLE 0.04 ADDED ITEM -03 DIMENSION 5.00 CHANGED FOR 7.25, DIMENSION 9.25 CHANGED FOR 11.00, DIMENSION Ø.55 ▽ .75 REMOVED, DIMENSION .08 AND Ø.74 REMOVED AND REPLACE BY "MIN RELIEF" NOTE, DIMENSION 0.20 AND 15.0° ADDED FOR CHAMFER, MATERIAL 4140/4142 HEAT TREAT 28-34 RC ZINC PLATE TYPE 1 CHANGED FOR 4140(28-32 RC) BLACK OXIDE		19-714	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBEM12669/P-1 REV. E SHEET 1 OF 4 TITLE HOISTING TOOL ASSEMBLY SCALE NTS	
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED			
DATE 5/1/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. E
MFG. APPR.	JFC	RBEM12669/P-1	SHEET 3 OF 4
APPROVED		TITLE	SCALE
		HOISTING TOOL ASSEMBLY	NTS 
DATE	5/1/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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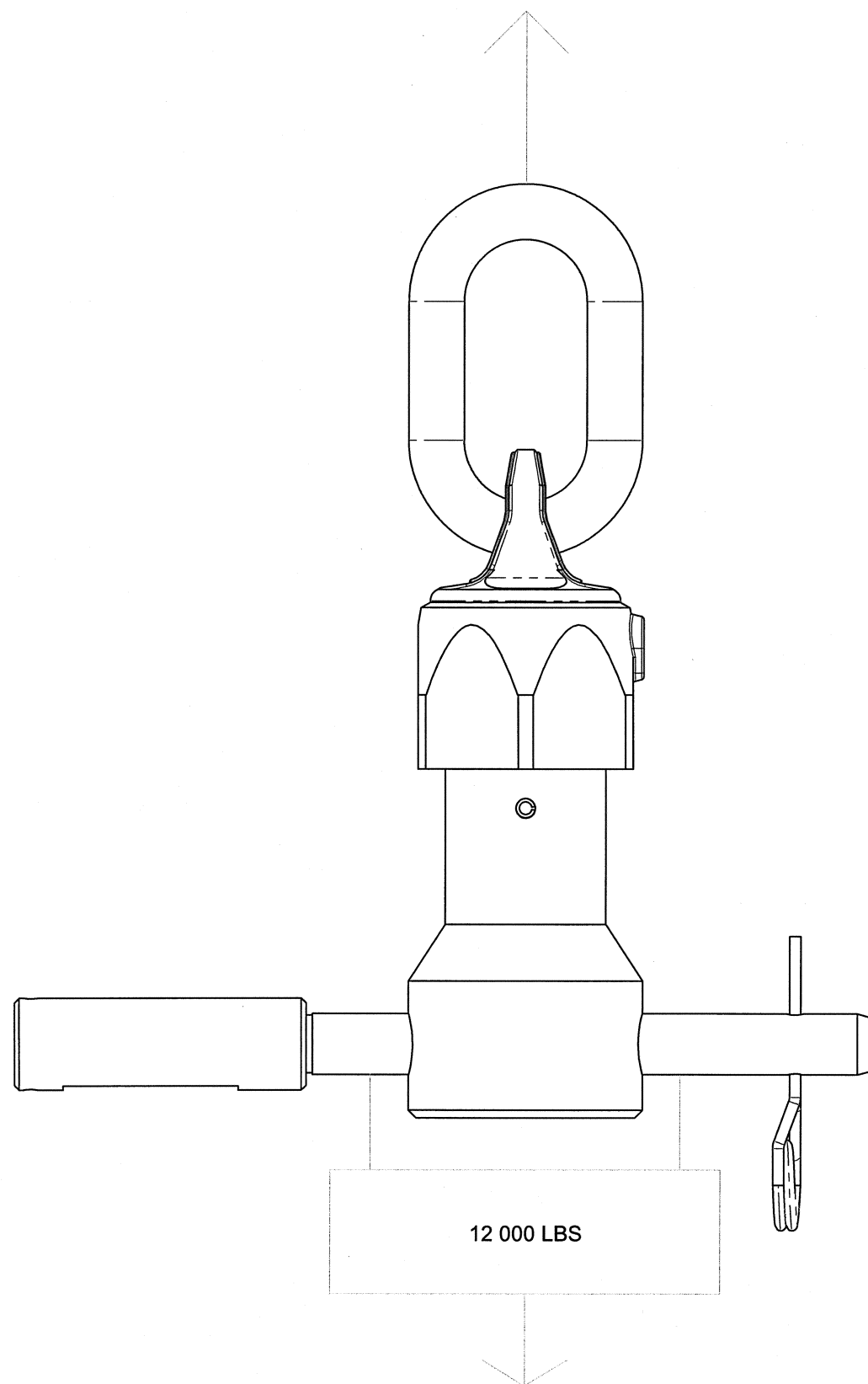
INSPECTION & TESTING PROCEDURE FOR THE RBEM12669/P-1,
HOISTING TOOL ASSEMBLY. THIS TOOL IS DESIGNED FOR LIFTING THE
EC135, H135, AND EC635 HELICOPTER.
THIS HOISTING TOOL SHOULD BE INSPECTED BEFORE AND AFTER
EACH USE.

**REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED
OF DAMAGE BEFORE USING!**

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE HOISTING TOOL ON AN OVERHEAD
LIFTING DEVICE. ATTACH HOISTING TOOL TO AN APPROPRIATE TEST
WEIGHT TEST OF 12,000 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY
CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR
DAMAGE.
3. REMOVE WEIGHT AND RE-INSPECT, CHECKING FOR ANY
CRACKS, DEFLECTION, DISTORTION OR DAMAGE.

INSPECTOR: _____
TESTER: _____
S.N.: _____
DATE: _____



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. E
MFG. APPR.	JFC	RBEM12669/P-1	SHEET 4 OF 4
APPROVED		TITLE	SCALE
		HOISTING TOOL ASSEMBLY	NTS
DATE 5/1/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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